

LISTING OF THE CLAIMS

Claims 1 and 2: (canceled).

3 (currently amended): A rolling method for a flat-rolled metal material, for executing rolling by using rolling equipment including a rolling mill and a coiling device for coiling a rolled material on the exit side of said rolling mill having a mechanism in which either one, or both, of the upper and lower roll assemblies support a work roll, by split backup rolls split into at least three segments in an axial direction, said split backup roll group having a construction for supporting both a vertical direction load and a rolling direction load acting on said contacting work roll, and each of said split backup rolls independently having a load measuring device, said method comprising the steps of:

calculating a left-right balance of a rolling direction force acting on the work roll of said rolling mill through the rolled material on the basis of a measured value of said split backup roll load of said rolling mill; and

controlling a left-right ~~swivelling component~~ difference of roll gap of said rolling mill.

Claims 4 and 5: (canceled).

6 (currently amended): A rolling apparatus for a flat-rolled metal material comprising:

a rolling mill having a construction in which either one, or both, of upper and lower roll assemblies support a work roll by split backup rolls split into at least three segments in an axial direction, said split backup roll group having a construction for supporting both a vertical direction load and a rolling direction load acting on said contacting work a roll, each of said split backup rolls independently having a load measuring device;

a coiling device for coiling said rolled material, arranged on the exit side of said rolling mill;

a calculation device for calculating a left-right balance of a rolling direction force acting on said work roll contacting said split backup rolls on the basis of the measured value of the split backup roll load of said rolling mill;

a calculation device for calculating a control quantity of a left-right ~~swivelling component~~ difference of roll gap of said rolling mill on the basis of the calculated value of the left-right balance of the rolling direction force; and

a control device for controlling the roll gap of said rolling mill on the basis of the calculated value of the left-right ~~swivelling component~~ difference control quantity of the roll gap.